

**Work Order ID 57986**

April 21, 2010 10:07:22 AM



Page 1

Item ID: D3641-1

Revision ID:

Item Name: Cover

Start Date: 21/04/2010 Start Qty: 8.00

Accept



Setup

Start



Required Date: 28/04/2010 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:



Date: 10-4-21

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3641

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

10-4-21

FLOW CNC Waterjet

5052 032

1-Cut as per Dwg D3641

Dwg Rev:

Prog Rev:

2-Deburr if necessary

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

10-4-21

Quality Control

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

S01019

(10)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 57986**

April 21, 2010 10:07:22 AM



Page 2

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Item Name: Cover

Start Date: 21/04/2010 Start Qty: 8.00

Accept



Setup

Start



Required Date: 28/04/2010 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

SD 10/05/20

10

6

Brake NC

NC BRAKE

0.00

Brake NC

Memo

0.00

Form as per Dwg D3641-1

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

SD 10/05/20

+10

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

SD 10/05/25

10

9

Hand Finishing

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 57986**

April 21, 2010 10:07:22 AM



Page 3

Item ID: D3641-1

Accept



Setup Start



Revision ID:

Item Name: Cover

Stop



Start Date: 21/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

160

QC3- Inspect Part Finish



QC

Quality Control

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location: 260

0.00

10 BL 10-5-25

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10-5-26 QDQSP10/05/26 10/05/26  
10/05/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

April 21, 2010 10:07:26 AM

Page 1

Work Order ID: 57986



Parent Item: D3641-1



Parent Item Name: Cover

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC  
IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.032						100	sf	76.0000	6.7259	325	B10-5-14	

5052-H32 .032 Sheet

## Warehouse

### Location

#### Main Warehouse

MAT23	76	
100470	3	
103321	3	
105998	7	
108462	10	
109478	9	
111448	3	
112664	38	
15031	3	

(10)

117664

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	5798C
Description: Cover	Part Number:	D3641-1
Inspection Dwg: D3641	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## First Article Prototype

Measured by:	<u>CB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-5-19	Date:	10/05/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

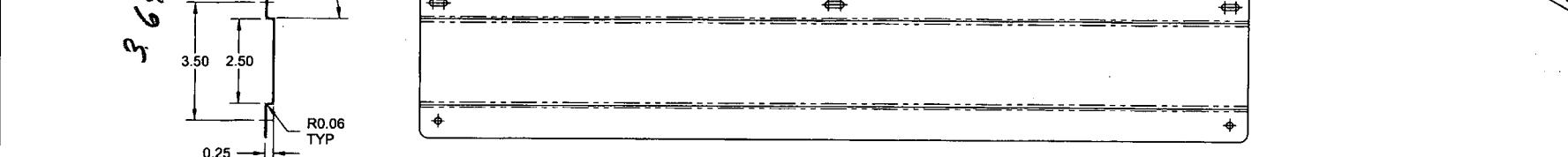
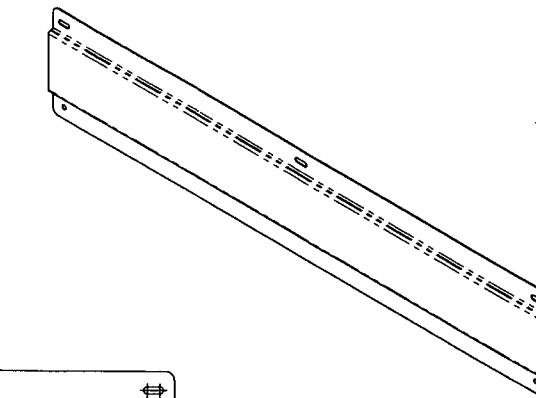
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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 57984  
BJS 10-4-21

D3641-1 COVER  
(REPLACES GENEVA P/N G10606-3/-6)  
(MAKE FROM D3641-1F FLAT PATTERN)

NOTES:  
 1) MATERIAL: D3641-1F FLAT PATTERN  
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.35 lbs

8 7 6 5 4 3 2 1

C	REFORMAT DRAWING TO CURRENT STANDARDS; D3641-3 WAS -4 (ZN C4-2); ADD D3641-4 VIEW (ZN A4-2); MOVE -1F-3F FLAT PATTERN TO SHEET 3. PER NCR 09-076	RF	09.10.02
B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	(P)	DRAWING NO.	REV. C
MFG. APPR.	(M)	D3641	SHEET 1 OF 3
APPROVED	(M)	TITLE	SCALE
DE APPR.	(M)	COVER	NTS
DATE	09.10.02	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPRIETARY INFORMATION OF DART AEROSPACE USA, INC. IT IS EXEMPTED FROM THE TRADE SECRETS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR Duplicated OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

A

D

C

B

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

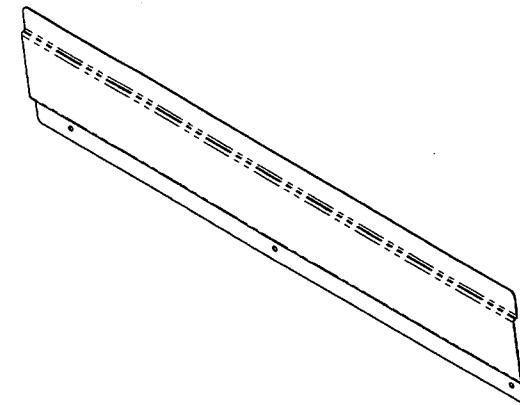
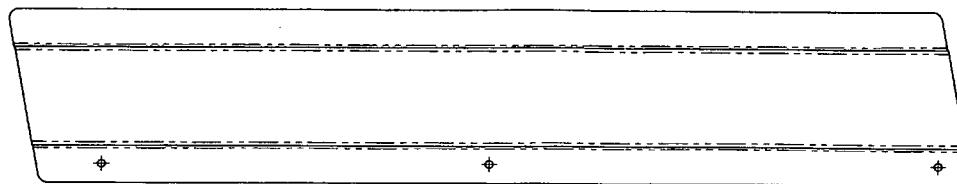
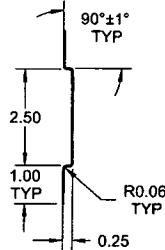
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3

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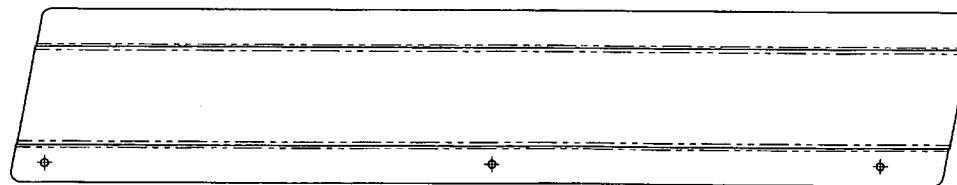
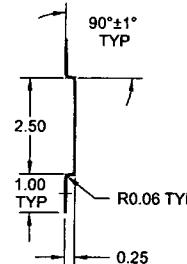
D



**D3641-3 COVER**  
**(REPLACES GENEVA P/N G10606-5)**   
 (MAKE FROM D3641-3F FLAT PATTERN)

D3641-3 COVER (SHOWN)  
 D3641-4 COVER (OPPOSITE)

W057986



**D3641-4 COVER**  
**(REPLACES GENEVA P/N G10606-4)**   
 (MAKE FROM D3641-3F FLAT PATTERN)

**NOTES:**

- 1) MATERIAL: D3641-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

8

7

6

5

4

3

2

1

DESIGN	TS	DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED		DRAWING NO.
MFG. APPR.		REV. C
APPROVED		SHEET 2 OF 3
DE APPR.		TITLE
DATE 09.10.02		SCALE
		NTS
COVER		

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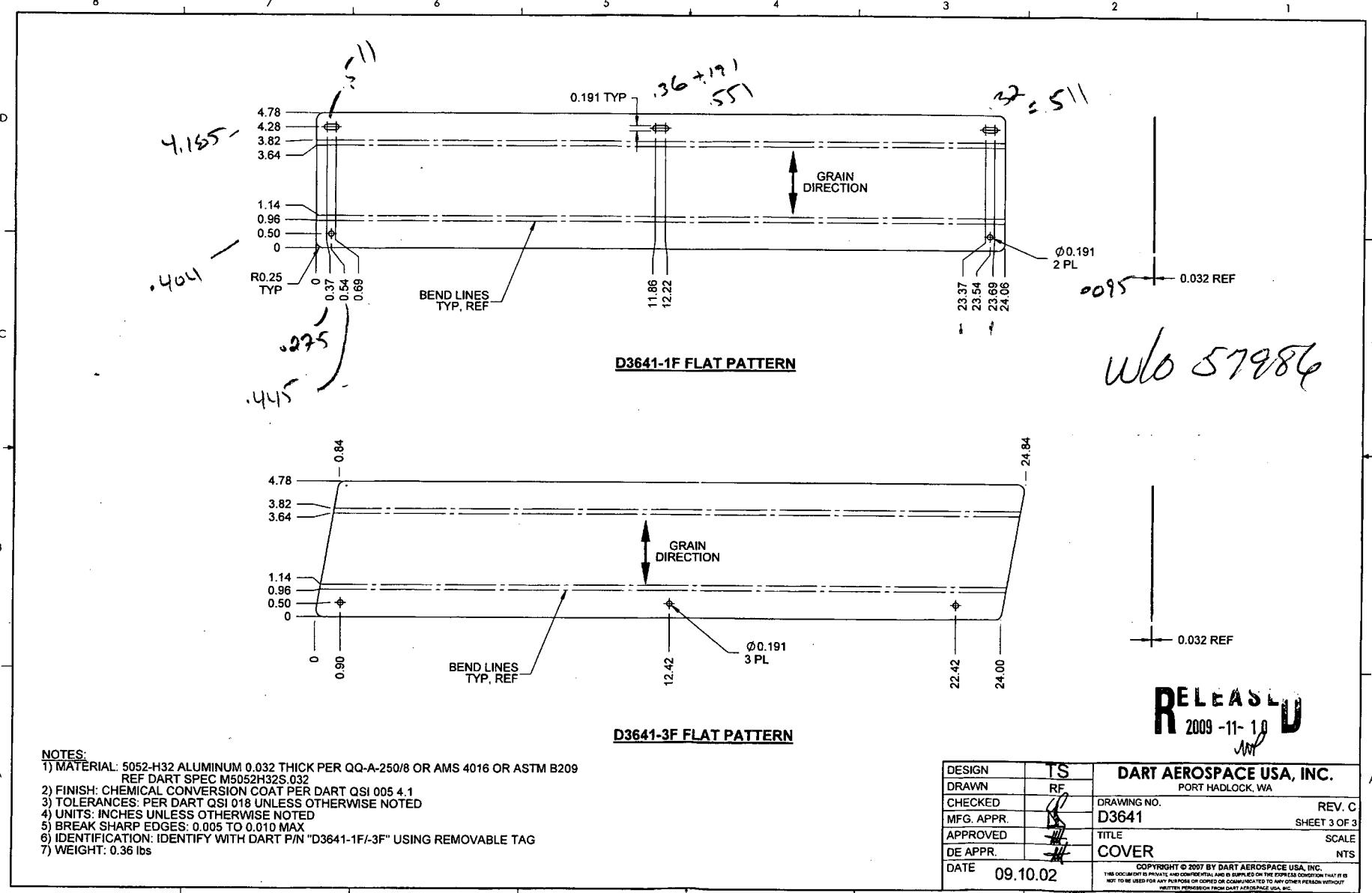
RELEASED  
 2009-11-10  
 MM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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